

# Work Order ID 52936

October 19, 2009 11:02:44 AM



Page 1

Item ID: D3992-2  
Revision ID: A  
Item Name: Reinforcement

Accept



Setup Start



Stop



Start Date: 10/19/09 Start Qty: 4.00  
Required Date: 11/02/09 Req'd Qty: 4.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: *RP* Date: *09-10-09* Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3992	A								

100

0.00



Waterjet  
FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3992  
Dwg Rev: *A*  
Prog Rev: *A*

2-Deburr if necessary

*B 9-10-28*

*(6)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC  
Quality Control

Memo

0.00

*B 9-10-28*

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Page 2

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Accept

Setup Start

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Stop

Item Name: Reinforcement

Start Date: 10/19/09 Start Qty: 4.00

Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control



⇒ 508/10/28

46

4

8009/11/04

61

4

⇒ 508/10/28

42  
46



4




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Page 3

Item ID:	D3992-2	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Reinforcement					
Start Date:	10/19/09	Start Qty: 4.00		Cust Item ID:		
Required Date:	11/02/09	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00		as 09/11/10		(X6)	0		
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00		BR 09-11-10		(6)			
170  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00  0.00				9/11/10		(6x) 50	

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Page 4

Item ID: D3992-2  
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Item Name: Reinforcement

Accept



Setup Start



Stop



Start Date: 10/19/09 Start Qty: 4.00  
Required Date: 11/02/09 Req'd Qty: 4.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/11/11  
mf  
09-11-10

# Picklist Print

October 19, 2009 11:02:49 AM

Page 1

Work Order ID: 52936

Parent Item: D3992-2

Parent Item Name: Reinforcement

Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	284.9347	0.3499	.5		



6061-T6 .080 Sheet

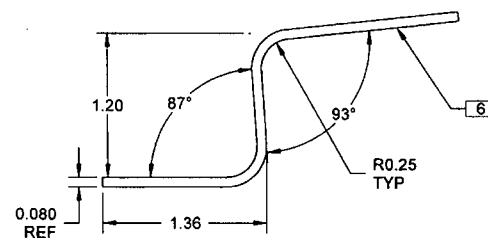
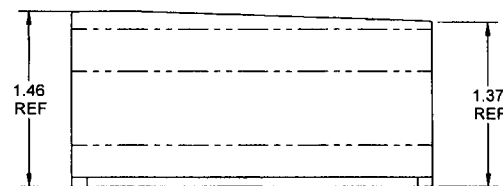
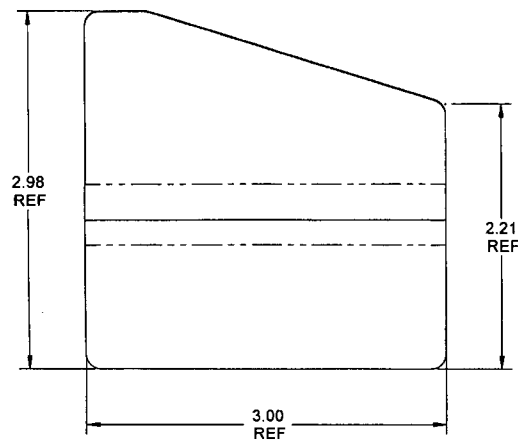


189-10-29

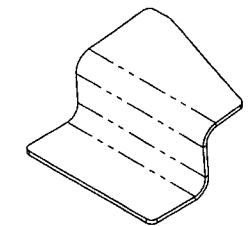
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<u>Location</u>		
Main Warehouse		
MAT	284.9347	
107904	0.02	
110254	2.5	
110630	38.0926	
112040	0.0437	
112141	33	
112512	19.2784	
112763	192	

112763





**D3992-1 REINFORCEMENT**  
MADE FROM D3992-1F



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NO. 53936

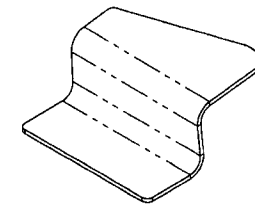
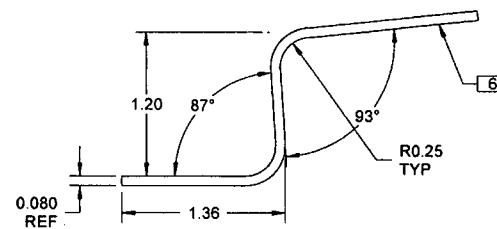
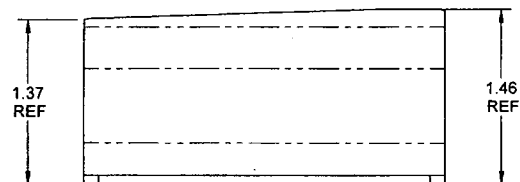
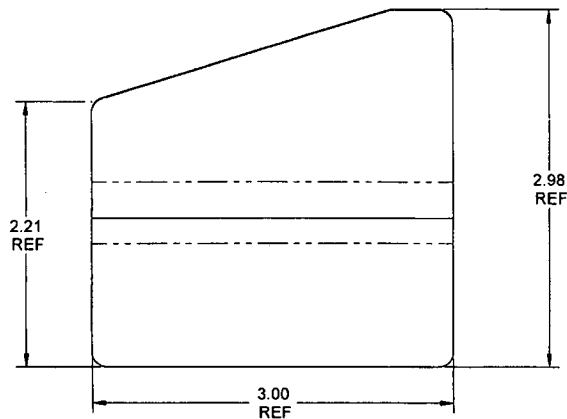
*12/09/10/10*

**RELEASE**  
2009-10-08  
*W*

**NOTES:**

- 1) MATERIAL: MADE FROM D3992-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3992-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

A	NEW ISSUE		09.09.28
REV.	DESCRIPTION	BY	DATE
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DRAWN			
CHECKED	<i>AS</i>		
MFG. APPR.	<i>E</i>		
APPROVED	<i>W</i>		
DE APPR.	<i>H</i>		
DATE	09.09.28		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	SHEET 1 OF 6
DRAWING NO. D3992		TITLE	SCALE
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**D3992-2 REINFORCEMENT**  
 MADE FROM D3992-1F

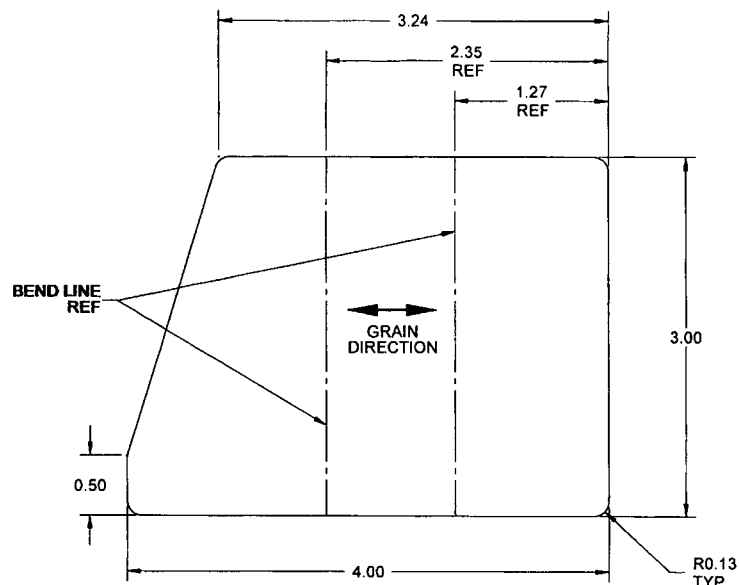
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**NOTES:**

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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3992-2" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

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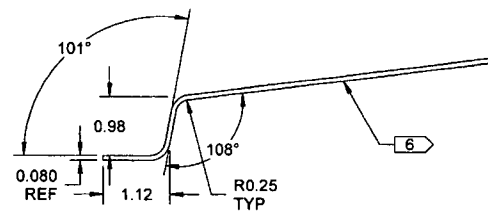
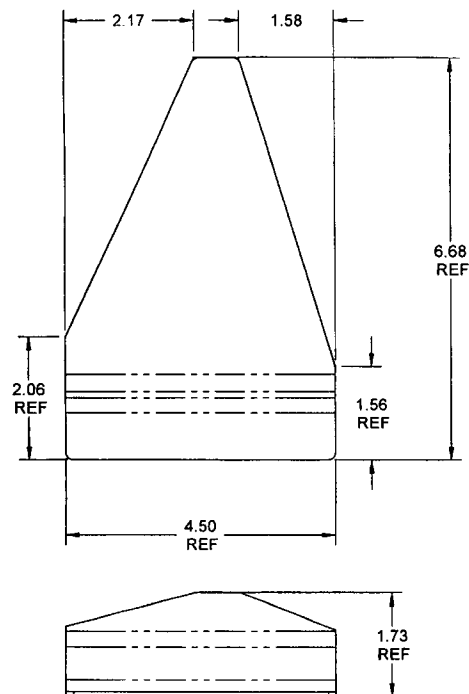
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**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

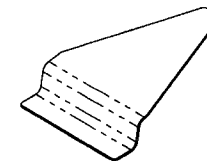
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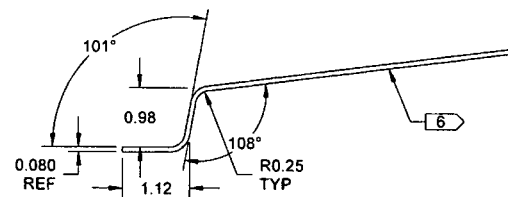
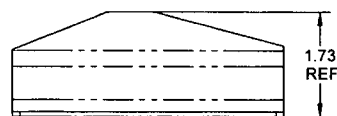
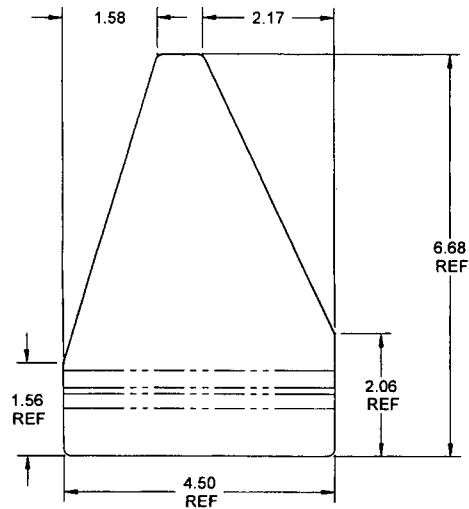
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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3992-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs



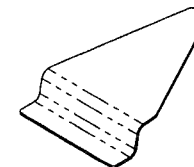
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**D3992-4 REINFORCEMENT**  
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**NOTES:**

- 1) MATERIAL: MADE FROM D3992-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3992-4" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs

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